

Work Order ID 139430

139430

Page 1

November 30, 2015 9:34:09 AM

Item ID: D2370-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Litter Frame Assembly

Start Date: 11/30/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 12/14/2015 Req'd Qty: 6.00 *6* Customer:

Reference:

20151130

Approvals: Process Plan: 36 Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2370	REV D

100 0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue p/o: 30595

Order: Model 12-2A undrilled with grey pad & black belts

Supplier: Ferno Aviation

Letter of compliance required

NOV 30 2015

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Insure that letter of compliance is attached to w/o

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

6

DAS
32

DEC 08 2015

6x Sp15-1203

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 139430

November 30, 2015 9:34:09 AM

139430

Page 2

Item ID: D2370-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Frame Assembly

Start Date: 11/30/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/14/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Small Fab

6 FS DEC 09 2015

Small Fab

Memo

0.00

1- Assemble D2374 STUDS WITH HARDWARE as per Dwg D2370
2-Assemble d2379 belt as per dwg

140

QC5- Inspect part completeness to step on W/O 0.00

140

QC

Memo

0.00

Quality Control

Check for loose rivet and ensure fit of D4812-041

(6) DAS
38
9-99
DEC 11 2015

150

Identify as per dwg & Stock Location: St208 0.00***150***

Packaging

Memo

0.00

Packaging

LOCATION : GA

1 DAS
38
9-99
DEC 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

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20151216

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐											

Picklist Print

November 30, 2015 9:34:17 AM

Page 1

Work Order ID: 139430

139430

Parent Item: D2370-1

D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 11/30/2015

Required Date: 12/14/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1P		Purchased	No				Each	0.0000					
D2370-1P									**				
Litter Frame Assembly													
D2374		Manufactured	No				Each	15.0000		24			
D2374									**				
Stud													
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				ST006		15			B137525				
				134906		15			9				
D2378		Manufactured	No				Each	27.0000		24			
D2378									**				
Bolt													
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				ST006		2							
				131082		2							
				ST007		25							
				135568		25							
D2484		Manufactured	No				Each	74.0000		24			
D2484									**				
Locknut													
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				GA		24							
				135829		24							
				ST007		50							
				135436		50							

6x SP15-12-03

FF DEC 09 2015

FF DEC 09 2015

DEC 09 2015

24

Picklist Print

November 30, 2015 9:34:18 AM

Page 2

Work Order ID: 139430

139430

Parent Item: D2370-1

D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 11/30/2015

Required Date: 12/14/2015

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0416J

Purchased

No

Each

4,549.000

24

NAS1149D0416.J

FF

DEC 09 2015

WASHER

Location

Loc Qty

Loc Code

GA

341

m131511

341

ST260a

1992

m131511

1992

ST270

2216

m131511

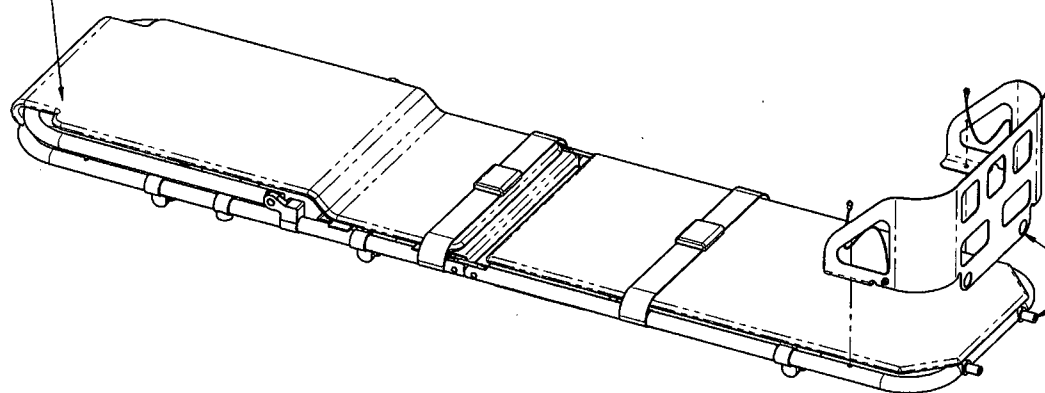
2216

24

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

D2370-1 LITTER FRAME ASSEMBLY



D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

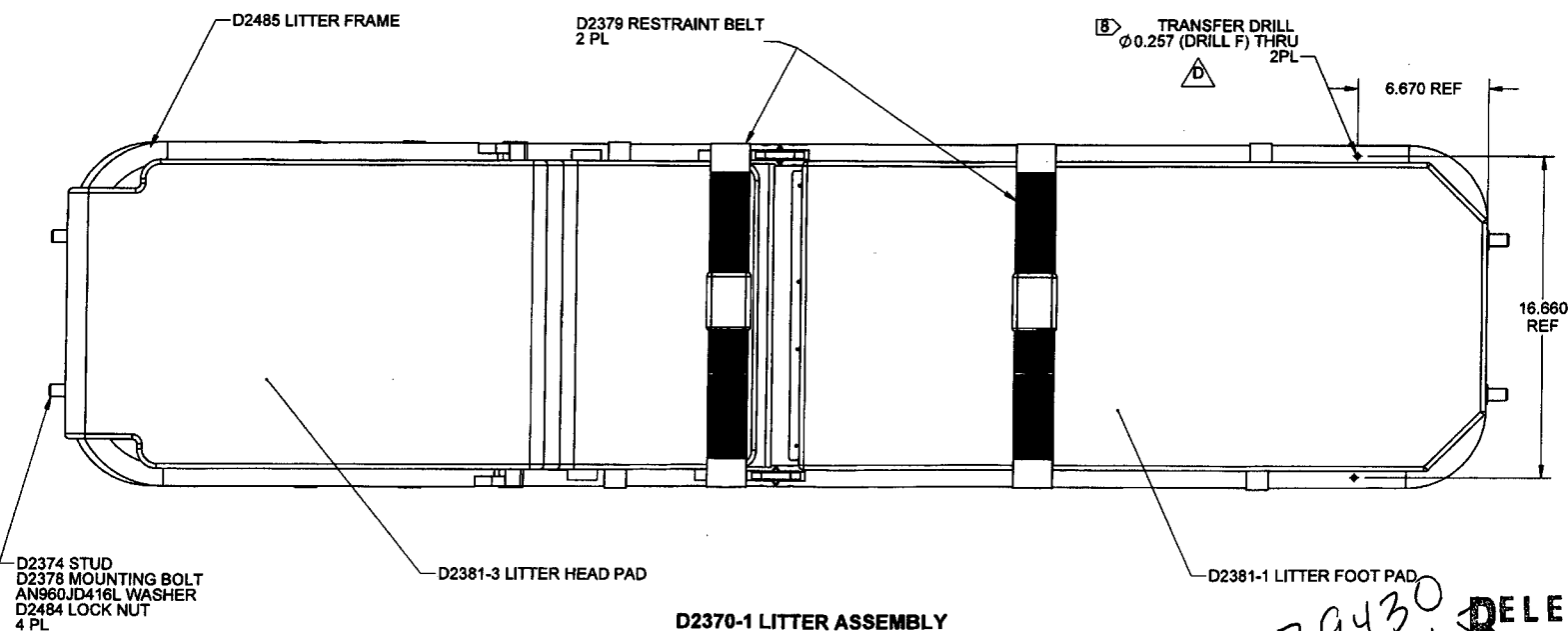
RELEASED
2013-05-16
MD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 25.73 Lbs

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (2N C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2370 REV. D LITTER ASSEMBLY SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED	<i>A.P.</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.03.27		

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QSI 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D2370	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-05-16



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30595**

Purchase Order Date 11/30/2015

PO Print Date 11/30/2015

Page Number 1 of 2

Order From :

VU-FER001

Ship To : DART AEROSPACE LTD

FERNO AVIATION INC.
735-B BRANCH DR.
ALPHARETTA,, GA 30004
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 770 521 1005

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

USD

Ship Via:

FedEx Economy

FOB

EXW - (Ex Works)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2370-1P ✓ AS PER DWG D2370 REV. D B139430 MODEL 12-2A UNDRILLED WITH GREY PAD & BALCK BELTS	Litter Frame Assembly	12/7/2015 Yes 12/7/2015		6.00 Each	\$1,706.00	\$10,236.00
						Line Total:	\$10,236.00
2	71401-45 Procurement Quality Clauses A005 right of entry A016 personnel qualification A026 certification of material conformance A040 notification of quality escape A041 quality management system A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	12/7/2015 No 12/7/2015		1.00	\$0.00	\$0.00
						Line Total:	\$0.00

PO Instructions: Fedex Acc#151793240

Note:

11/30/2015

FERNO Aviation, INC.

735-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

Packing Slip

DATE	PACKING SLIP NO.
11/30/2015	16285

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO30595

P.O. NUMBER	TERMS	REP	SHIP DATE	SHIP VIA	FOB	
PO30595	Net 30	CW	11/30/2015		Alpharetta, GA	
ITEM	DESCRIPTION				QTY ORD.	QTY DEL.
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints (HS Code 8803.30.00.00)., Serial # 15N335664, 15N335665, 15N335666, 15N335667, 15N335668, 15N335669				6 ✓	6 ✓

2015-12-03

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FERNO Aviation, INC.

Commercial Invoice

735-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

DATE	INVOICE NO.
11/30/2015	16285

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO30595

PO NO.	TERMS	REP	SHIP DATE	SHIP VIA	FOB
PO30595	Net 30	CW	11/30/2015		Alpharetta, GA
ITEM	DESCRIPTION	QTY	UNIT PRICE	AMOUNT	
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints (HS Code 8803.30.00.00), Serial # 15N335664, 15N335665, 15N335666, 15N335667, 15N335668, 15N335669	6	1,706.00	10,236.00	✓
				Total	\$10,236.00



P 937.382.1451
F 937.382.1191

70 Weil Way
Wilmington, Ohio 45177

877.733.0911
www.ferno.com

2015

Burn Certificate

Order No. 174224

Reference P.O. Ferno Aviation PO#: 9210
Dart PO30595

Model No. Model 12-2 Emergency Stretcher

Item Number: Ferno-Washington #
0163255 12-2 STRETCHER GRAY

Ferno Catalog Number: N/A

Serial Nos. ~~15N332662, 15N335663, 15N335664, 15N335665, 15N335666,~~
15N335667, 15N335668, 15N335669, ~~15N335670, 15N335671~~

We certify that the material(s) listed above complies in all respects with the flammability requirements of the Department of Transportation Federal Aviation Administration FAR 25.853 appendix F Part I (a)(1)(ii).

FAR 25.853 "...The average burn length may not exceed six inches and the average flame time, after removal of the flame source, may not exceed 15 seconds. Drippings from the test specimen may not continue to flame for more than an average of three seconds after falling.

Dorothy Deaton
Vice President of Global Legal and Regulatory Compliance



P 937.382.1451
F 937.382.1191

70 Weil Way
Wilmington, Ohio 45177

877.733.0911
www.ferno.com

21 August, 2015

Certificate of Conformance

Supplier: Ferno-Washington Inc.

Supplier Address: 70 Weil Way
Wilmington, Ohio 45177 USA
937-382-1451

Order No. 174224

Reference P.O. Ferno Aviation PO#: 9210
Part PO30595

Model No. Model 12-2 Emergency Stretcher

Item Number: Ferno-Washington #
0163255 12-2 STRETCHER GRAY

Ferno Catalog Number: N/A

Serial Nos. ~~15N332662, 15N335663, 15N335664, 15N335665, 15N335666,~~
15N335667, 15N335668, 15N335669, ~~15N335670, 15N335671~~

I certify that the above referenced products are produced in accordance with applicable Ferno-Washington Inc. quality standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices.

Ferno-Washington Inc. is a registered manufacturer (Registration No. 1523574) with the United States Food and Drug Administration (FDA) as a manufacturer of medical devices, the Quality Management System is in compliance to the FDA's Code of Federal Regulations 21 CFR Part 820.

Ferno-Washington, Inc. also maintains a Quality Management System that fulfills the requirements of ISO 9001:2008 and ISO 13485:2003. Copies of Ferno-Washington, Inc.'s ISO 9001 and ISO 13485 certificates issued by Intertek are available upon request.

Dorothy Deaton
Vice President of Global Legal and Regulatory Compliance